

24 hour work life

6207 is a gray, one-component, UV/heat dual cure, precision mixed, degassed, and frozen acrylate adhesive that bonds well to most substrates (metals, ceramic, glass, and most plastics). It has the capabilities of both a deep UV cure and full shadow cure with heat and is ideal for fiber optic applications. It is a free-flowing material with a long work life, able to be dispensed up to 24 hours after thaw. 6207 can be tacked with UV, removed from the fixture, and post cured with heat later in the assembly process. It offers a low coefficient of thermal expansion to minimize part movement during thermal cycling.

UNCURED	
Work Life @ 25°C	24 hours
Viscosity @ 23°C	35,000 cPs
Shelf Life @ -40°C	12 months
CURE OPTIONS	Based on cure of 6,000 mJ + 30 minutes @ 120°C
CURED PROPERTIES	Based on cure of 6,000 mJ + 30 minutes @ 120°C
Color	Gray
Shore D Hardness	94
Glass Transition Temp (°C)	125
Density (g/cc)	1.6
Lap Shear 2024T3 Clad (psi)	1,500
ELECTRICAL PROPERTIES	Based on cure of 6,000 mJ + 30 minutes @ 120°C
Volume Resistivity (ohm-cm)	1.0E 12 @ 500 VDC
THERMAL PROPERTIES	Based on cure of 6,000 mJ + 30 minutes @ 120°C
CTE below Tg (ppm/°C)	43
CTE above Tg (ppm/°C)	98
Glass Transition Temp (°C)	125
OUTGASSING PROPERTIES	Based on cure of 6,000 mJ + 30 minutes @ 120°C
TML (%)	0.32
CVCM (%)	<0.01
WVR (%)	0.16
ACOUSTIC PROPERTIES	
Velocity (m/s)	3,035
Impedance (MRayls)	4.98
Loss (dB/cm-MHz)	-5.05
Density (g/cc)	1.6

KEY FEATURES

Bonds Well to Most Substrates

Deep UV Cure

Full Shadow Cure with Heat

Ideal for Fiber Optic Applications

Long Pot Life

Fast Tack Minimizes Fixture Costs

Secondary Cure after Removal from Fixture

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